

Work Order ID 57965

April 21, 2010 9:17:22 AM



Page 1

Item ID: D4038-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle. Fwd. LH

Start Date: 21/04/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 4.00

Customer:

Reference:

[Signature]

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4038

B

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank 7.125" long

mmv
08/04/21

4 0

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg & Folio FA880

Dwg Rev: *B*

Folio Rev: *B*

Deburr

mmv
10/04/24

4.0

Work Order ID 57965

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Page 2

Item ID: D4038-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle, Fwd, LH

Start Date: 21/04/2010 Start Qty: 4.00

Required Date: 30/04/2010 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2-Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

MV= 10/04/24

4 0

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

amt 10/04/26

4 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

(H)

Bk 10-4-26

Work Order ID 57965

April 21, 2010 9:17:23 AM

Page 3

Item ID: D4038-1

Accept

Revision ID:

Item Name: Angle, Fwd, LH

Start Date: 21/04/2010 Start Qty: 4.00

Required Date: 30/04/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location:

G.A Sylvie

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/27
MF 10-4-26

Picklist Print

April 21, 2010 9:17:22 AM

Page 1

Work Order ID: 57965

Parent Item: D4038-1

Parent Item Name: Angle, Fwd, LH


Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Start Date: 21/04/2010

Required Date: 30/04/2010

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M6061T6A4.000W.250 | | Purchased | No | | | 100 | f | 14.5000 | 2.5263 | | | |
|  | | | | | | | | | | | | |
| 6061T6 ANGLE 4.00 x 4.00 x .250 | | | | | | | | | | | | |

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT06

113391

14.5

14.5

mmf
10/04/21

2.9474

| | | |
|-----------------------------|--------|---------------------|
| DART AEROSPACE LTD | | Work Order: 57965 |
| Description: Angle, Fwd. LH | | Part Number: 4038-1 |
| Inspection Dwg: 4038 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

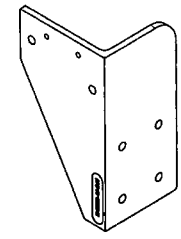
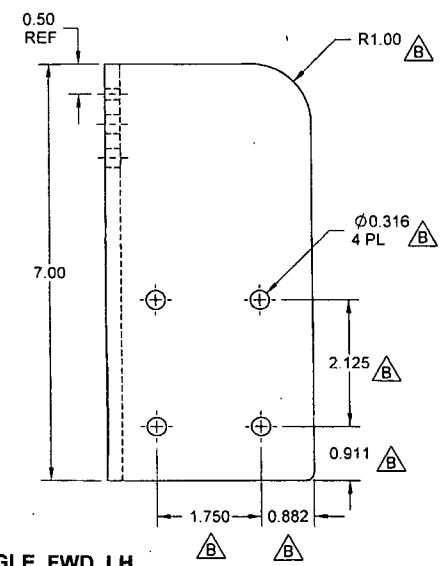
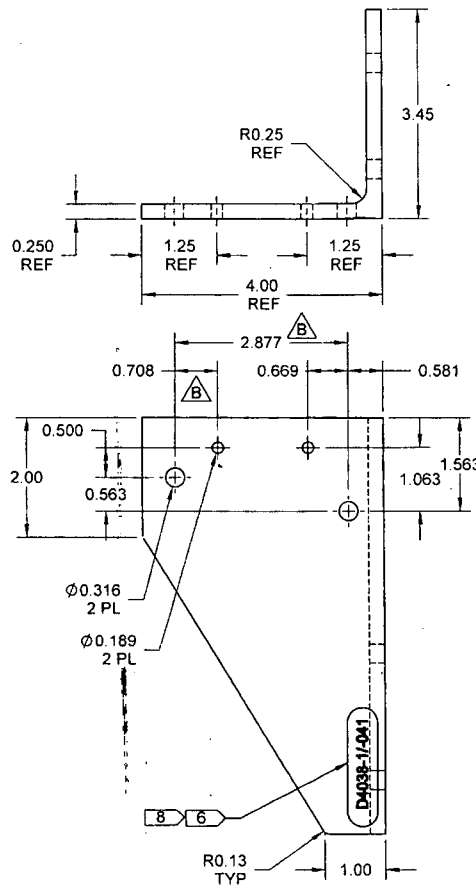
☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 3.45 | ± .03 | 3.44 | ✓ | | | |
| .250 | ± .010 | .240 | ✓ | | | |
| 2.877 | ± .010 | 2.877 | ✓ | | | |
| .708 | ± .010 | .708 | ✓ | | | |
| .669 | ± .010 | .670 | ✓ | | | |
| .581 | ± .010 | .579 | ✓ | | | |
| 1.563 | ± .010 | 1.561 | ✓ | | | |
| .500 | ± .010 | .500 | ✓ | | | |
| 2.00 | ± .03 | 2.00 | ✓ | | | |
| 1.00 | ± .03 | 1.00 | ✓ | | | |
| Ø .316 | + .006 - .001 | .317 | ✓ | | | |
| Ø .189 | + .005 - .001 | .192 | ✓ | | | |
| 7.00 | ± .03 | 7.00 | ✓ | | | |
| 1.750 | ± .010 | 1.747 | ✓ | | | |
| 2.125 | ± .010 | 2.122 | ✓ | | | |
| .911 | ± .010 | .908 | ✓ | | | |
| .882 | ± .010 | .880 | ✓ | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | | |
|------------------|-------------------------|-------------------------|
| Measured by: AMU | Audited by: [Signature] | Prototype Approval: N/A |
| Date: 10/04/24 | Date: 10/04/26 | Date: N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |

a/p 57965



D4038-1 ANGLE, FWD, LH

RELEASED
2010-04-14
MJD

- NOTES:
- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
 - 7) WEIGHT: 1.04 lbs
 - 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

| | | | |
|------------|----------|---|---------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D4038 | SHEET 3 OF 14 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BRACKET | NTS |
| DATE | 10.01.05 | <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

Work Order ID 57966

April 21, 2010 9:18:37 AM



Page 1

Item ID: D4038-2

Revision ID:

Item Name: Angle. Fwd. RH

Start Date: 21/04/2010 Start Qty: 4.00

Required Date: 30/04/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4038

B

100

0.00



Bandsaw

Memo

Cut Blank 7.125" long

0.00

Jeaspa Bandsaw

mw
10/04/21

4 8

110

0.00



HAAS I

Memo

Mill as per Dwg & Folio FA880

Dwg Rev: 8

Folio Rev: 44

Deburr

0.00

HAAS CNC vertical machine #1

mw
10/04/25

4 8

Work Order ID 57966

April 21, 2010 9:18:37 AM



Page 2

Item ID: D4038-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle, Fwd. RH

Start Date: 21/04/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

mw 10/04/25

4 0



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

mk 10/04/26

4 0



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

(4)

BL 10-4-26

Work Order ID 57966

April 21, 2010 9:18:37 AM

Page 3

Item ID: D4038-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Angle. Fwd. RH

Start Date: 21/04/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

G.A Sylvie m-h 10/04/26



10/04/27 MF 10-4-26

Picklist Print

April 21, 2010 9:18:37 AM

Page 1

Work Order ID: 57966

Parent Item: D4038-2

Parent Item Name: Angle, Fwd, RH

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Start Date: 21/04/2010

Required Date: 30/04/2010

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M6061T6A4.000W.250 | | Purchased | No | | | 100 | f | 14.5000 | 2.9474 | | | |



6061T6 ANGLE 4.00 x 4.00 x .250

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT06

113391

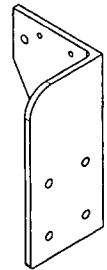
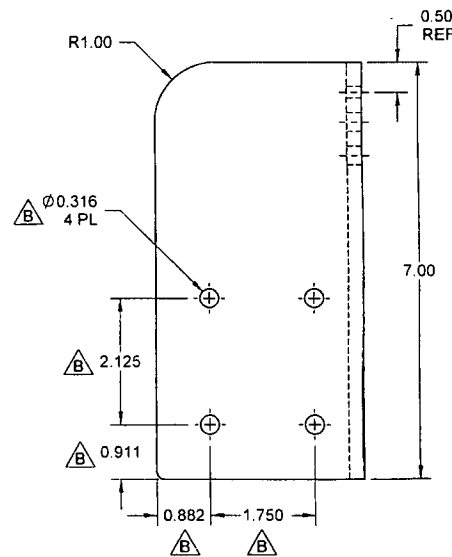
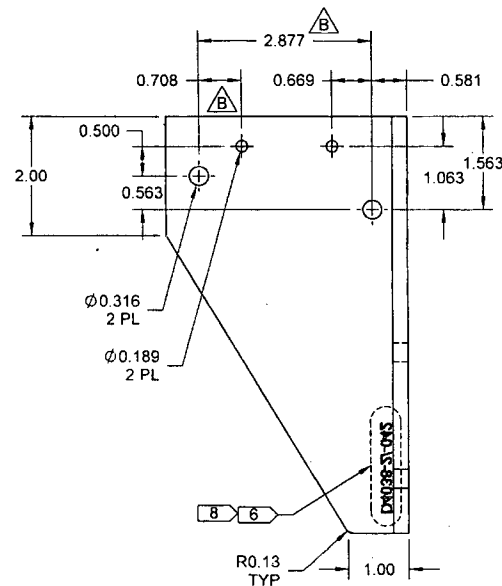
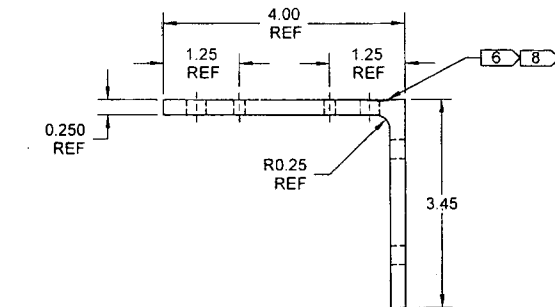
14.5

14.5

mml
10/04/21

2.9474

v/p 57966



D4038-2 ANGLE, FWD, RH

RELEASED
2010-04-11

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (FAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.04 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

| | | | |
|------------|----------|--|---------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D4038 | REV. B |
| MFG. APPR. | | | SHEET 4 OF 14 |
| APPROVED | | TITLE BRACKET | SCALE |
| DE APPR. | | | NTS |
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